

SYSTEM AND METHOD FOR  
HOLDING AND RELEASING A WORKPIECE  
FOR ELECTROCHEMICAL MACHINING

ABSTRACT OF THE DISCLOSURE

A system and method are described for holding and releasing a workpiece for electrochemical machining. In one embodiment, a workpiece holder has a workpiece surface that couples to the workpiece when negative pressure is applied to provide a seal between the workpiece and the workpiece surface. A plenum located within the workpiece holder has a proximal end capable of being removably coupled to the workpiece. A piston is configured to move upward in the plenum and to lift the workpiece off of the workpiece surface in response to positive pressure being applied.